

# Work Order ID 55109

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Page 1

Item ID: D044-717-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cold Weather Baffle

Start Date: 1/6/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 1/12/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *10-01-06* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D044-717-011CHG001

*8/10/07*

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

*10-1-6 (40) SP*

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

*2) 8/10/07*

*74*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 55109

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Item ID: D044-717-011

Accept



Setup Start



Revision ID:

Item Name: Cold Weather Baffle

Stop



Start Date: 1/6/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 1/12/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per PPP D044-717-011								
	Location: <u>10</u>								
	PPP Rev: <u>B</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

10-1-7 SP

10/01/07  
JMF 10-01-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 55109

Parent Item: D044-717-011

Parent Item Name: Cold Weather Baffle

Comments:


Start Date: 1/6/2010


Required Date: 1/12/2010


Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3276-041		Manufactured	No			110	Each	4.0000	4.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>Baffle Assembly LH</p> </div> <div> <p>Warehouse Location</p> <p>Main Warehouse</p> <p>ST</p> <p>52373</p> </div> <div> <p>Loc Qty</p> <p>4</p> </div> <div> <p>Loc Code</p> <p></p> </div> <div> <p>4</p> </div> <div> <p>10-1-6</p> </div> <div> <p>SP</p> </div> </div>												

D3276-042		Manufactured	No			110	Each	6.0000	4.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>Baffle Assembly RH</p> </div> <div> <p>Warehouse Location</p> <p>Main Warehouse</p> <p>ST</p> <p>54450</p> </div> <div> <p>Loc Qty</p> <p>4</p> </div> <div> <p>Loc Code</p> <p></p> </div> <div> <p>4</p> </div> <div> <p>10-1-6</p> </div> <div> <p>SP</p> </div> </div>												

D3383-1		Manufactured	No			110	Each	7.0000	4.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>Placard</p> </div> <div> <p>Warehouse Location</p> <p>Main Warehouse</p> <p>ST</p> <p>39690</p> <p>52723</p> </div> <div> <p>Loc Qty</p> <p>7</p> <p>1</p> <p>6</p> </div> <div> <p>Loc Code</p> <p></p> </div> <div> <p>4</p> </div> <div> <p>10-1-6</p> </div> <div> <p>SP</p> </div> </div>												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 55109

Parent Item: D044-717-011

Parent Item Name: Cold Weather Baffle

Comments:

Start Date: 1/6/2010

Required Date: 1/12/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN526C1032R7 / <i>XB</i>		Purchased	No			110	Each	114.0000	32.0000			
--------------------------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--

*S* *H* Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 114

104394 3

113064 100

113096 11

110 Each 7,633.000 64.0000

*10-1-6* *sf*

MS20426AD3-4 / <i>HL</i>		Purchased	No			110	Each	7,633.000	64.0000			
--------------------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--

*S* *H* RIVET

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 7633

104374 3633

110398 4000

110 Each 83.0000 32.0000

*10-1-6* *sf*

MS21059L3 / <i>HS</i>		Purchased	No			110	Each	83.0000	32.0000			
-----------------------	--	-----------	----	--	--	-----	------	---------	---------	--	--	--

*S* *H* Nut Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 83

109962 11

111925 72

*10-1-6* *42* *sf*

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



## CHAPTER 53 – FUSELAGE (53-00-00)

### 53.1 COLD WEATHER BAFFLE KIT REMOVAL

The Dart D044-717-011 Cold Weather Baffle Kit should be removed as follows:

- 53.1.1 Unfasten the qty(4) AN526C1032-7 screws securing the D3276-041 Baffle Assembly to the LH inlet. Remove the baffle assembly.
- 53.1.2 Unfasten the qty(4) AN526C1032-7 screws securing the D3276-042 Baffle Assembly to the RH inlet. Remove the baffle assembly.
- 53.1.3 If removing because temperatures are above -10°C (14°F), plug all nut plates with the AN526C1032-7 screws.

### 53.2 COLD WEATHER BAFFLE KIT REINSTALLATION

The Dart D044-717-011 Cold Weather Baffle Kit should be reinstalled as follows:

- 53.2.1 Locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 0-1 so that holes in baffle line up with nut plates that have already been installed in airframe. Install using qty(4) AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 53.2.2 Repeat installation for RH side using D3276-042 Baffle Assembly.

### 53.3 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-717-011	0.86 lb	0	0	160 in	138 in-lb
Cold Weather Baffle Kit	0.39 kg	0	0	4.06 m	1.6 m-kg

### 53.4 PARTS LIST

Qty -011	Part Number	Description
X	D044-717-011	COLD WEATHER BAFFLE KIT
1	D3276-041	BAFFLE ASSEMBLY, LH
1	D3276-042	BAFFLE ASSEMBLY, RH
1	D3383-1	PLACARD
8	AN526C1032-7	SCREW
16	MS20426AD3-4	RIVET
8	MS21059L3	NUTPLATE

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**53-00-00**

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Page 1

Item ID: D044-717-011

Accept

Revision ID:

Item Name: Cold Weather Baffle

Start Date: 1/6/2010 Start Qty: 4.00

Required Date: 1/12/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: *mf*

Date: 10-01-06 Tooling:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D044-717-011CHG001

*Pl 10-1-06*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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